Work Order	r ID 112482 1:45:26 AM		*112	2482	<b>)</b> *					· · ·		Page 1
Revision ID:	03594-043		Accept	*N9	იიი	<b>040</b>	100	)*	Setup	Start	171	S1*
	Floor Doubler Assembly, LH  1/30/14 Start Qty: 4.00  1/30/14 Req'd Qty: 4.00	*4* *4*			st Item I stomer:	D:				Stop		S2*
	Process Plan: MLブ QC:	Date: <u>\\-0\-3\</u>	Tooling: _ SPC (Y/N):		i	ate:			Run	Start Stop	^IV	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Т	ool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr											
D3594	Rev B											
*100 *100* Waterjet FLOW CNC Waterjet GOCe 1 . OS	Dwg Rev:		0.00					4			. /	14/04/0

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\* QC

Memo

0.00

Quality Control

DQA:		Date	:		WORK OPPER NON		<b></b>	DAAANGE / LIDDATE				DART
QA Closed:		Date	:		WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
Work Order:					DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstul Machining Small Famororming Finishi Large Fab Composi	ab	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	1		]	Desc	ription of work order update		nitial	Action		Sign &		
Cause	Da	te Step	Qty		or non-conformance		ief Eng	i e		Date	Verification	QC Inspector
Design  Doc/Data  Equip/Tooling  Handling/Pre  Material  Operator  Offset/Setup  Process  Supplier  Training  Transport  Unapproved												
						FA	ULT CA	TEGORY				
Landing	Bend Cent Crac Crim Cuff Crus Head Insp Mar	re Not Conc ks p/Kink/Ripp s	le/Wave In Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function		Grain Hardwa Inspect Instruc Misalia Mislaba Misrea Off-set Out of	ion Incomplete/Unqualified tions Incomplete/Unclear gned/off center eled d		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct issing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other

Work Ord	er ID	112482
Ianuary_30_14	11.45.26	$\Delta M$

# \*112482\*

Page 2

January-30-14	11:45:26 AM			· 1 1 /	48/"						1 age 2	
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	1/30/14	Assembly, LH  Start Qty: 4.00  Req'd Qty: 4.00	*4 <sup>2</sup> *4 <sup>2</sup>		*N900 Cust Item Customer	ID:	100	<b>)*</b> s	etup Sta	17	S1* S2*	
Approvals:		in:				Date:	_	R	tun Sta	OD	R1* R2*	
Sequence ID/ Work Center II 120 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - second Memo	ond check	Set Up/ Run Hours 0.00 27 3-19 0.00 M	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
130 *120* Small Fab Small Fab		Small Fab  Memo C'SINK AS	PER DWG D3594	0.00	MAG			_5_			14/04/09	, D
140 <b>*1 4 \*</b> QC Quality Control		QC5- Inspect part compl	eteness to step on W	, 9.	AS 27 89			5				

DQA:			Date:										_	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_	_	AEROSPACE
QA Closed:			Date:							<u> w</u>	ork Order up	odate only	⊥	
Work Orde	er:					DISPOSITION			AGAINS'	T DE	PARTMENT	/PROCESS		
	•					Rework	1		Skid-tube Crosstube		1	Water Jet	$\neg$	Engineering
Part N	lo.					Scrap	1 1		Machining Small Fal	$\vdash$	Pro	d. Eng. Coor.	7	Quality
	•					Use-as-is	1 1		noforming Finishing		4	re/Packaging		Other
NCR N	io.					Suspected Unapproved	]		Large Fab Composite		]	Supplier		
Root	ſ				Desci	ription of work order update	ı	nitial	Action		Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification		QC Inspector
Design	$\Box$		: :											
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Equip/Tooling														
Handling/Pre			:									į		
Material														
Operator														
Offset/Setup	$\dashv$			·			1							
Process	$\dashv$										i			
Supplier	_													
Training	_													
Transport	_					•								
Unapproved		. <u> </u>	i		<u> </u>		FA	III T CA'	TCORY		<u> </u>			
l a madia		`				Conord	FA	ULT CA	TEGORY					
Landii		Bending			<u> </u>	<b>General</b> Bend		ارمانه را	Program		Outside Dim	onsions F	٦,	Pressure/Forced
		Centre No	at Concor	atric	┢	BOM/Route	$\vdash$	Grain	riogram	$\vdash$	Over/Under	<u> </u>		Set-up
		Cracks	or concer	itiic	-	Broken/Damage/Defect	-	Hardwa	ara	-	Part Incorre	<u> </u>	_	Temperature/Cure
		Crimp/Kir	rk/Rinnle	/\ <i>M</i> >ve	-	Burrs	-	4	ion Incomplete/Unqualified		Part Lost/Mi	<b>⊢</b>	_	Weld
		Cuffs	іку пірріс	, wave		Contamination	-	1 '	tions Incomplete/Unclear		Part Moved		_	Wrong Stock Pulled
		Crushing				Countersink		₹	gned/off center	$\vdash$	Positioned V		┙	Wilding Stock i dired
[	-	Heat Trea	nt		-	Cut Too Short		Mislabe	-	$\vdash$	Power Loss/		$\neg$	Other
	_	Inspection		Tube	-	Drawing	$\vdash$	Misrea		L	J. 55, 2000)			
		Marks/Ch				Drill Holes	$\vdash$	Off-set						
		Turning S			-	Finish		4	Calibration					
		Wave/Tw				Fit/Function		4	Sequence					

Work Orde				*112	2482*							Page 3	
Item ID: Revision ID: Item Name:	D3594-043 Floor Double	т Assembly, LH		Accept	*N90	<b>0040</b>	100	)*	Setup	Start Stop	*N	S1*	
Start Date: Required Date: Reference:	1/30/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Iter Custome					•	^{\\ ,	S'2^	
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop	*N	R1*	
Sequence ID/ Work Center II	D	Operation Description Chemical Conversion Co	pat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp	
*150* HandFinish Hand Finishing		Memo		0.00				5		H.	Kf:G-0	Ĵ	
<sup>160</sup>		QC7-Inspect Chemical C	Conversion Coat	0.00				51	,			// lost.	DA 36 9-89
QC Quality Control		Memo		0.00				<u> </u>				14/04/10	<b>)</b>
170 *170*		Small Fab		0.00				5				14/hdl	) 3 9-6
Small Fab		Memo		0.00					<del>-</del> —			.1121/10	7

Install Nut Plates As per Dwg D3594

Small Fab

DQA:			Date:										TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	er:					DISPOSITION	İ		AGAINST	DE	PARTMENT	/PROCESS	
Work Orac			<del></del>		_	Rework			Skid-tube Crosstube	Г	]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	1	Pro	d. Eng. Coor.	Quality
	-				_	Use-as-is		Thern	noforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	No.					Suspected Unapproved			Large Fab Composite		]	Supplier	
Root					Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design											1		
Doc/Data			ļ										
Equip/Tooling													
Handling/Pre													
Material	Ш											1	
Operator	Щ										ļ	i	
Offset/Setup	Ш								:				
Process	Н						ĺ		,				
Supplier					İ				,				
Training							١						
Transport Unapproved	-		:										
Onapproved			<u>.                                    </u>				FΔI	UIT CA	TEGORY			L	
Landi	nø G	iear				General		<del></del>			<u> </u>		
		Bending				Bend	Г	Folio/F	Program	Г	Outside Dim	ensions	Pressure/Forced
	Н	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	<del></del>	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	<b>-</b>	Temperature/Cure
	-	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/M	issing	Weld
	$\vdash$	Cuffs				Contamination		4 `	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	-	Crushing				Countersink	$\vdash$	4	gned/off center		Positioned V		<del>_</del>
		Heat Trea	at			Cut Too Short		Mislab	eled	Г	Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ct	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence				

Work Order ID 112482 \*112482\* January-30-14 11:45:26 AM Item ID: D3594-043 Accept \*N900040100\* Setup Start **Revision ID: Item Name:** Floor Doubler Assembly, LH **Start Date:** 1/30/14 Start Qty: 4.00 \*4\* **Cust Item ID:** Required Date: 1/30/14 Req'd Qty: 4.00 \*4\* **Customer:** Reference: Run Start **Approvals:** Process Plan: Date:\_\_\_\_\_ Tooling: Date: Stop Date:\_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject **Work Center ID Description** Run Hourss Code Qty Qty Number Stamp 180 QC5- Inspect part completeness to step on W/O \*120\*

QC

190

200

QC

Quality Control

\*190\* Packaging

\*200\*

Quality Control

Packaging

Memo

Identify as per dwg & Stock Location: 572336 APR 1 0 2014 0.00 Memo

QC21- Final Inspection - Work Order Release 0.00 H 14-4-14 0.00 Memo

Page 4

Insp.

DQA:			Date:											TRAGE
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / L		۱۸/۵	ork Order up	date only	AEROSPACE
QA CIUSEU.			Date.				_	i			VVC	nk Older up	date only	1
Work Orde	er:					DISPOSITION		•		AGAINST	DEI	PARTMENT	PROCESS	
	-	<del></del>			_	Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap	i		Machining	Small Fab		Pro	d. Eng. Coor.	Quality
	•			•		Use-as-is			noforming	Finishing			e/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite		-	Supplier	1
												·		
Root					Desc	ription of work order update	l	nitial	ł .	ction		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription		Date	Verification	QC Inspector
Design						-								
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator							}							
Offset/Setup							Ì							
Process								•						
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Training														
Transport		·												
Unapproved														
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Landi	ng (	· ·			_	General				1			_	¬
	<u> </u>	Bending				Bend		•	Program			Outside Dim	<del></del>	Pressure/Forced
		Centre No	ot Concer	ntric	$\perp$	BOM/Route	<u> </u>	Grain				Over/Under	<del> </del>	Set-up
		Cracks			_	Broken/Damage/Defect	<u> </u>	Hardwa	are			Part Incorred	i _	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/l	Unqualified		Part Lost/Mi	_	Weld
		Cuffs				Contamination .		Instruc	tions Incomplete,	/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled
		Crushing				Countersink	L	Misali	gned/off center	-	-	Positioned V		7
	<u>_</u>	Heat Trea	at		_	Cut Too Short		Mislab	eled		L	Power Loss/	Surge	Other
		Inspection	-	Tube		Drawing		Misrea						
	L	Marks/Ch	natter		L	Drill Holes		Off-set						
		Turning S	equence		L	Finish	L	Out of	Calibration	•				
		Wave/Tw	ist in Tub	ре	-	Fit/Function		Out of	Sequence					

**Picklist Print** Page 1 January-30-14 11:45:25 AM Work Order ID: 112482 Parent Item: D3594-043 **Start Date: 1/30/14** Required Date: 1/30/14 Parent Item Name: Floor Doubler Assembly, LH Start Otv: 4.00 Required Qty: 4.00 Comments: IPP Rev : A New Issue 07-01-22 EC Component Item ID/ Replacement Mfg/ Bin Last **Primary** Unit of Qty per Kit Total Route Oty on Oty Date Status Item Name Item ID Purch Item Location Location Measure Hand Seq ID Oty Issued Issued M6061T6S.080 No Purchased 170 sf 234.1600 0.51 2.1473684 6061-T6 .080 Sheet Location Loc Oty Loc Code MAT021 234.16 m126309 2.2 218.9 15.26 MS20426AD4-4 No Purchased 100 Each 3,436.0000 Rivet Location Loc Oty Loc Code GA 339 129090 339 ST334 3097 125445 3097

170

Loc Qty

20

20

Each

20.0000

Loc Code

No

Location

m126274

ST317

Purchased

MS21069-5

Anchor nuts

DQA:			Date:										TRAGE
			D-4			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	١	ant Ondan	.data ank.	AEROSPACE
QA Closed:			Date:							VV	ork Order up	date only	<u> </u>
Work Orde	er:					DISPOSITION		:	AGAINS	T DE	PARTMENT	/PROCESS	
	-	····	· · · · · · · · · · · · · · · · · · ·			Rework	1		Skid-tube Crosstub	e l	1	Water Jet	Engineering
Part N	No.					Scrap	1		Machining Small Fa	-	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1	Therr	noforming Finishir	ıg 🗀	Rec/Sto	re/Packaging	Other
NCR I	۷o.					Suspected Unapproved	]		Large Fab Composit	e 🗀		Supplier	
		•							<u> </u>		,		
Root					Desc	ription of work order update	1	nitial	Action		Sign &	-	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design	Щ								<b>1</b>				
Doc/Data	Щ	!											
Equip/Tooling	Щ					•							
Handling/Pre	Н						1						
Material	$\vdash$												
Operator	$\vdash$												
Offset/Setup	Н												
Process	H												
Supplier	Н												
Training Transport	Н												
Unapproved	H		į										
Ollappioved			<u>l</u>	l			FA	ULT CA	TEGORY		1		<b>_</b>
Landi	ng (	Gear				General							
		Bending				Bend		]Folio/I	Program		Outside Dim	ensions [	Pressure/Forced
	Г	Centre No	ot Concer	ntric		BOM/Route		Grain	· ·		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci F	Temperature/Cure
	Г	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs				Contamination	Г	Instruc	tions Incomplete/Unclear		Part Moved	Γ	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned \	Vrong	<del></del>
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	natter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of	Calibration				
		Wave/Tw	vist in Tub	ре		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	112482
Description: Floor Doubler, LH	Part Number:	D3594-3
Inspection Dwg: D3594 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

<del></del>	7	T	· · · · · · · · · · · · · · · · · · ·	1	T	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.25	+/-0.030	1225			V5km-08	
7.85	+/-0.030	7.85	/		T5Km.07.	
7.313	+/-0.010	7.313				
2.688	+/-0.010	2.688				
Ø0.323	+0.006/-0.001	0.324	/			
Ø0.128	+0.005/-0.001	0.129	/			
0.359	+/-0.010	0.359				-
0.718	+/-0.010	0.718	/			
0.81	+/-0.030	0.81	/			
2.32	+/-0.030	2.32	/			
0.080	+/-0.010	0.079	J			
	,					

DAS

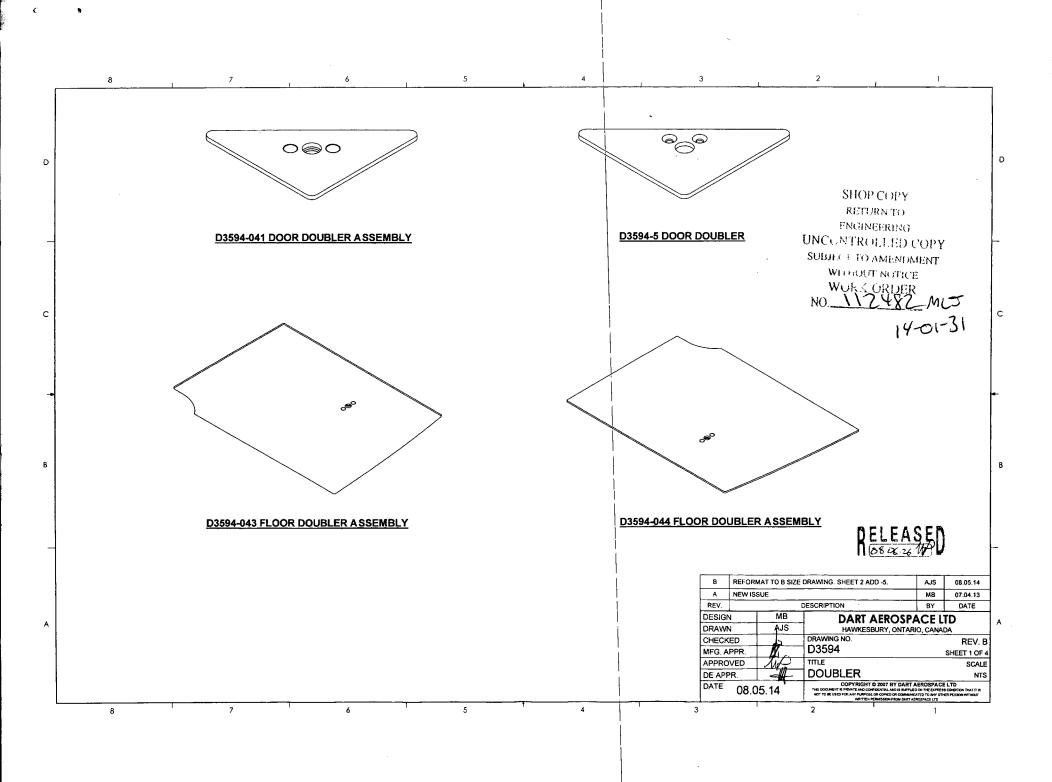
Measured by: M Date: Moy/07

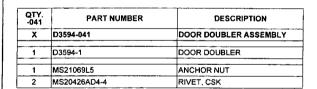
Audited by: 27
9-59
Prototype A

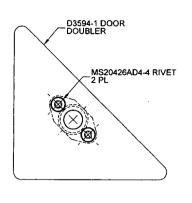
Prototype Approval: N/A

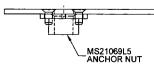
Date: N/A

Date	Change	Revised by Approved
07.07.18	New Issue P/O D3594-043	KJ/JLM
08.09.04	Dwg Rev updated	KJ/DD 10
09.05.07	Dimensions updated per Dwg Rev B	KJ/EC C
	07.07.18 08.09.04	07.07.18 New Issue P/O D3594-043 08.09.04 Dwg Rev updated









#### (4) D3594-041 DOOR DOUBLER ASSEMBLY

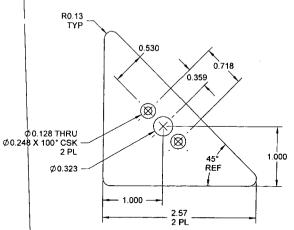
D

С

NOTES:
1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -041: 0 /4 lbs

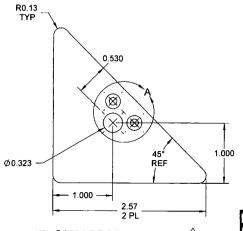
7) WEIGHT -041: 0.04 lbs -5: 0.03 lbs

Ø0.128 THRU Ø0.248 X 100° CSK -2 PL 0.508 0.359 2 PL



#### **D3594-1 DOOR DOUBLER**

2

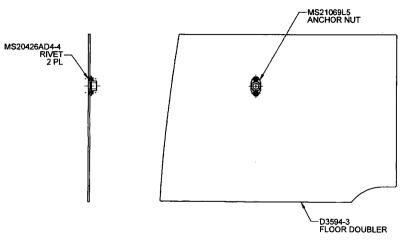


## 5 D3594-5 DOOR DOUBLER B

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	5.	DRAWING NO.	REV. B
MFG, APPR.	20	D3594	SHEET 2 OF 4
APPROVED	TVIII.	TITLE	SCALE
DE APPR.	44-	DOUBLER	NTS
DATE 08.05.14		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVITE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS	

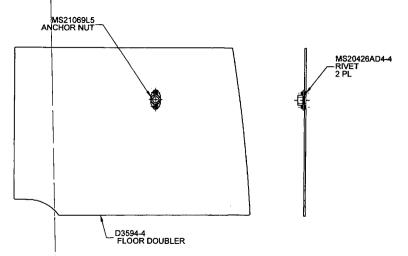
8

QTY. -043 QTY. PART NUMBER DESCRIPTION D3594-043 х FLOOR DOUBLER ASSEMBLY, LH Х D3594-044 FLOOR DOUBLER ASSEMBLY, RH D3594-3 FLOOR DOUBLER, LH D3594-4 FLOOR DOUBLER, RH MS21069L5 ANCHOR NUT 2 MS20426AD4-4 RIVET, CSK



#### D3594-043 FLOOR DOUBLER ASSEMBLY

NOTES:
1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T65.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) WEIGHT -043 & -044: 0.80 lbs



## D3594-044 FLOOR DOUBLER ASSEMBLY

D

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	77	D3594	SHEET 3 OF 4
APPROVED	143	TITLE	SCALE
DE APPR.	4	DOUBLER	NTS
DATE 08.05.14		THIS DOCUMENT IS PRIMATE AND COMPRISED THE DOCUMENT IS PRIMATE AND COMPRISED AND IS CUPRILED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPRISE OR COMPRISED TO COMPRISE OTHER PORTION PRIMATED TO THE AND PRIMATED PRIMATED PRIMATED TO AN AND PRIMATED PRIMA	

